

Date: Tuesday, 29/04/2008 10:52:37 AM
 User: Linda Lacelle

Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: TUBE
Job Number	: 38883		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D37701
This Issue	: 29/04/2008	S.O. No. :	Drawing Number : PROTOTYPE
Prsht Rev.	: NC	Project Number	: 08-04.23
First Issue	: / /	Type	: R & D SM/MED FAB
Previous Run	: 38876	Drawing Revision	:
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 16/05/2008
Comment	:	Qty:	6 Um: Each

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3770 REV A

FF 08-05-12

2.0

M6061T6T1000W065

6061T6 TUBE



Comment: Qty.: 1.2000 f(s)/Unit Total: 7.2000 f(s)

6061T6 TUBE

PH 08-05-23 6
 * 1107400 x 5 / 11107950 x 8 FF 08-05-12

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
 APPROVAL

C 08/05/12 (6) / PH 08-05-14

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI 005

PH 08-05-29 (6)
 08/05/14

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Date: Tuesday, 29/04/2008 10:52:37 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: TUBE

Job Number: 38883

Part Number: D37701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY

PL
08.05.29

CHARGE TO JOB #00196

7.0

QC21

FINAL INSPECTION/W/O RELEASE



CERTIFICATE OF CONFORMITY
REQUIRED



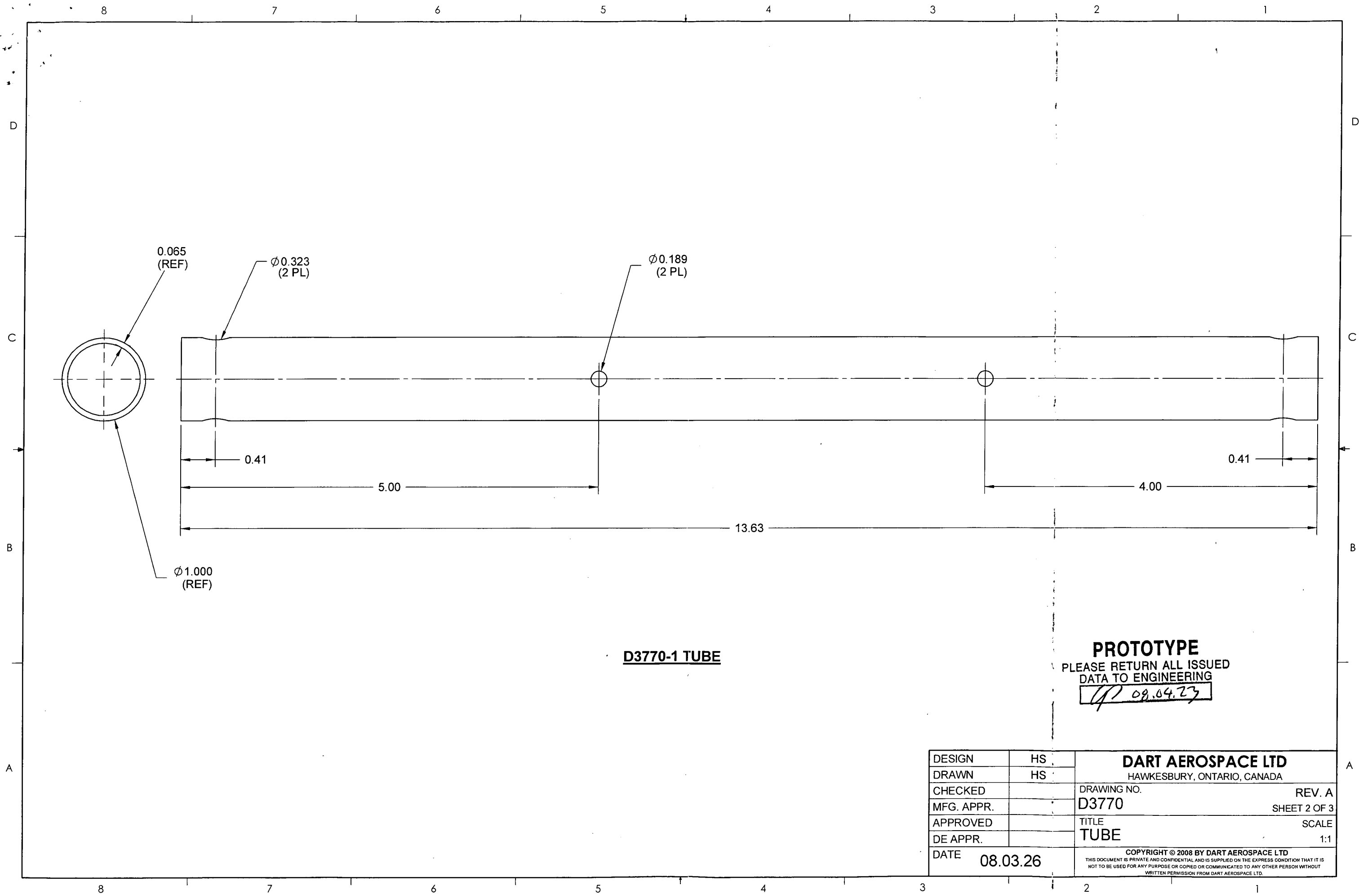
Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 Proton

Job Completion



u 08-06-08

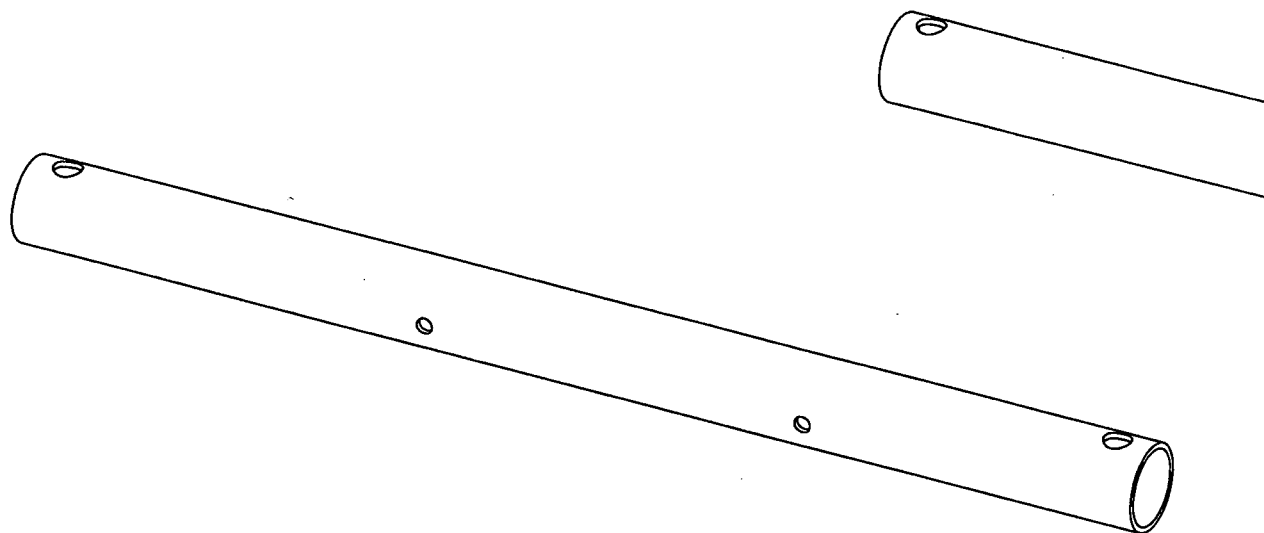


D

C

B

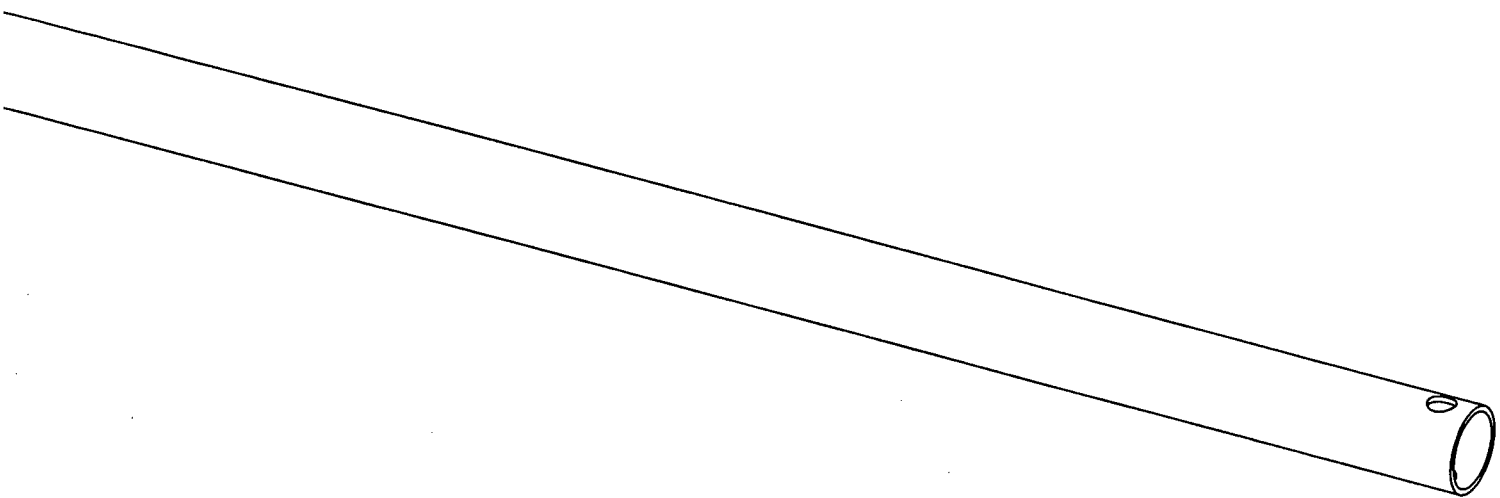
A



D3770-1 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M60)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs



4+

D3770-3 TUBE

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

41 08.04.23

M6061T6T1.000W.065)

REV.		DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED		DRAWING NO. D3770		REV. A	SHEET 1 OF 3
MFG. APPR.					
APPROVED		TITLE TUBE		SCALE	NTS
DE APPR.					
DATE 08.03.26		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Receiving Report

Date: 8/0/6
Supplier: MARMER

Batch No: M107950
Dart P/O: 6269

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐ N/A ☐
Shipment Complete: Yes ☒ No ☒ N/A ☐
QC6 Inspection ☒ N/A ☐
Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date: 08/05/08
Received/Costing: RCP 7822
Initial: CR

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

G.S.T. /HST	18.02
T.P.S.	
PROVINCIAL TAX	.00
TAXE PROVINCIALE	

TERMS: NET 30 DAYS
PLUS 2% PER MONTH ON
OVERDUE ACCOUNTS.

TERMES: NET 30 JOURS
PLUS 2% PAR MOIS
SUR COMPTE PASSE DÙ.

FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.
POUR LES CONDITIONS DE VENTE, VOUS TROUVEREZ LES
RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

PAYMENT OF THIS INVOICE IS DUE BY
LE RÈGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

06/04/2008

378.38

FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

02/18/2008 From: MARMON/KEYSTONE
M/K OR:
C.P.O.:
C PART:

INIT.:

To:

OR. REF:
SLSPRS:

KAISER
ALUMINUM
FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER: 80-33603		CUSTOMER PART NUMBER: AT/1.065/734		PRODUCT DESCRIPTION: Seamless Tube	
KAISER ORDER NUMBER: 200438	LINE ITEM: 005	SHIP DATE: 11/27/2007	KAISER LOT NUMBER: F00000606	ALLOY: 6061	TEMPER: T6
WEIGHT SHIPPED: 331,000 LB	QUANTITY: 123,000 PCS	BL NUMBER: 200274	DIAM/DEPTH/THK: 	WEIGHT: 	LENGTH: 12,000 FT
SHIP TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA			SEND TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA		

Actual Physical Properties

REFERENCE	DASH	SAMPLES	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONTRACT	REMARKS
F00000606	0001	1	46.5	42.6	17.0	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Er	Sa	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R22452	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

Wilfredo A. delacruz, Sr. Metallurgical Engineer

Plant Serial: 00000264

Wilfredo A. delacruz

Page 1 of 2

Kaiser Order Number: 200438

Line Item: 005

Q. C. REVIEWED

FEB 06 2008 13:10

AT 1.065 734

PAGE 02

18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14505414357

2/2008 From: MARMON/KEYSTONE
K OR:
C.P.O.:
C PART:

INIT.:

To:

OR. REF:
SLSPRS:

KAISER
ALUMINUM
FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round @
AMS-4082N ASTM-B210-04 WW-T-700/6F
WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 4082N, WAS NOT OILED.
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR
CANCELLED: MIL-T-7081, WW-T-700F/GEN, WW-T-700/2E, WW-T-700/3F,
WW-T-700/4F, WW-T-700/5E, WW-T-700/6F, WW-T-700/7E.
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204 *****
COMPLIES TO DIN EN 10204 JAN 2005

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's Sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Wilfredo A. de la Cruz

Page 2 of 2

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

FEB 06 2008 13:11

PAGE.03

** TOTAL PAGE.03 **